

# Work Order ID 59247

May 28, 2010 8:08:10 AM



# PRELIMINARY ISSUE

Page 1

Item ID: D3908-1

Revision ID:

Item Name: Lug Plate, Aft Crosstube

Start Date: 28/05/2010 Start Qty: 6.00

Required Date: 28/05/2010 Req'd Qty: 6.00

Reference:

*Handwritten:* 10-05-28

Approvals: Process Plan:

Date:

QC:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Tooling:

Date:

SPC (Y/N):

Date:



Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D3908

*Handwritten:* 8 PC1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3908

Prog Rev: *Handwritten:* PC1

Dwg Rev: *Handwritten:* PC1

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*Handwritten:* HB 10-5-28

*Handwritten:* 6

*Handwritten:* HB 10-5-28

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May 28, 2010 8:08:10 AM



Page 2

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 28/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00 → inspect to PCI Day



QC

Memo

0.00 8/20/28 (8/2)

Quality Control

150

Identify as per dwg & Stock Location: 94

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

A. Per only

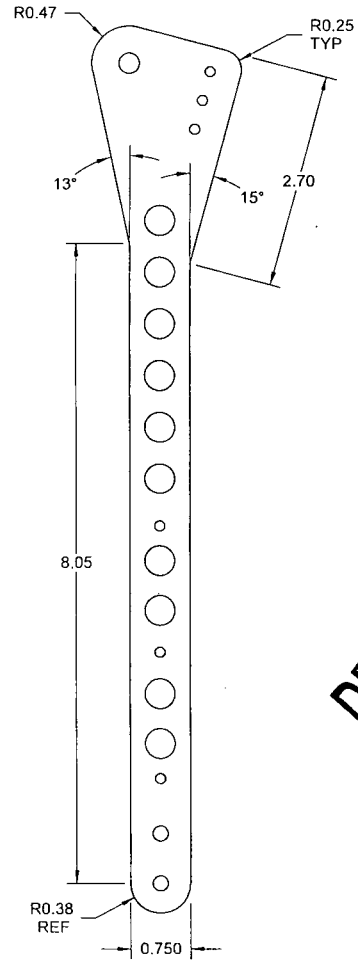
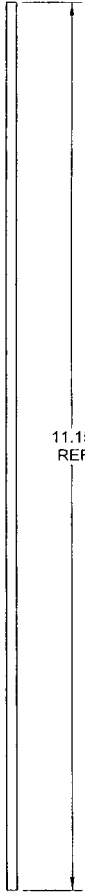
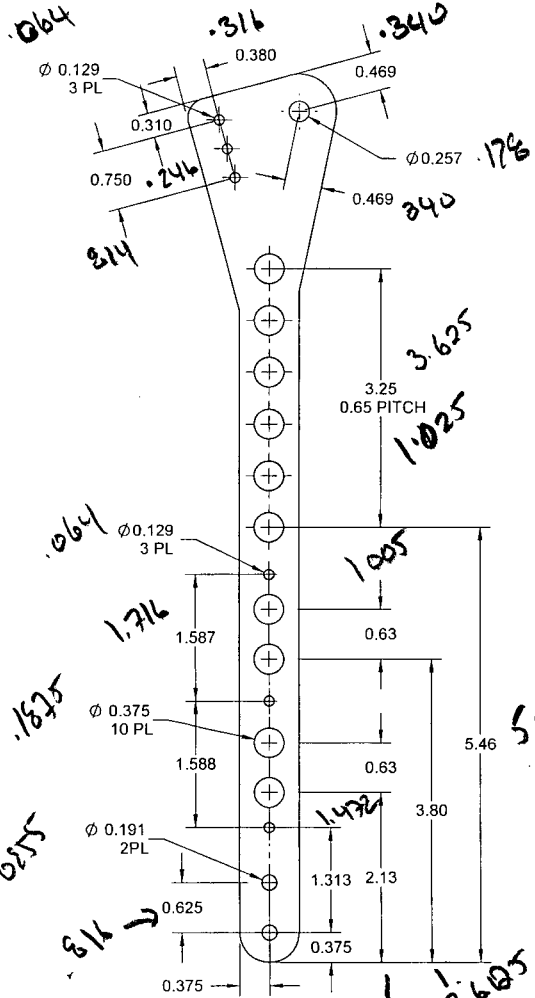
POSITIVE RECALL

EFFECTIVE 10/05/28 AUTH U

RELEASED U DATE 10.05.28

ME 10-5-28

W/O. 59247



PRELIMINARY ISSUE

59247

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE PC1

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 59247
Description: LUG PLATE		Part Number: D3908-1
Inspection Dwg: D3908-1 Rev: PC1		Page 1 of 1

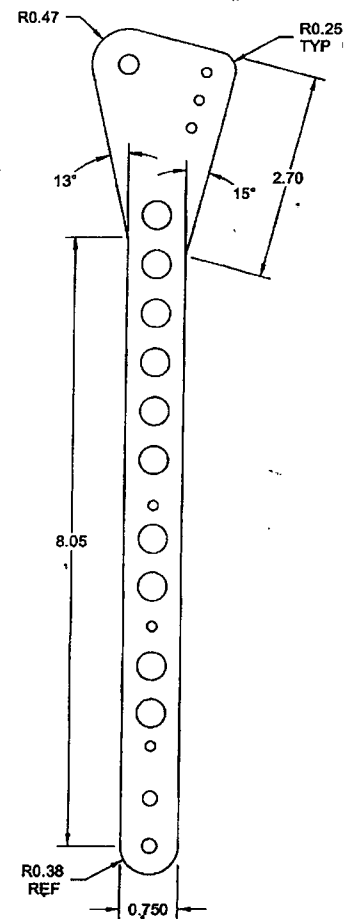
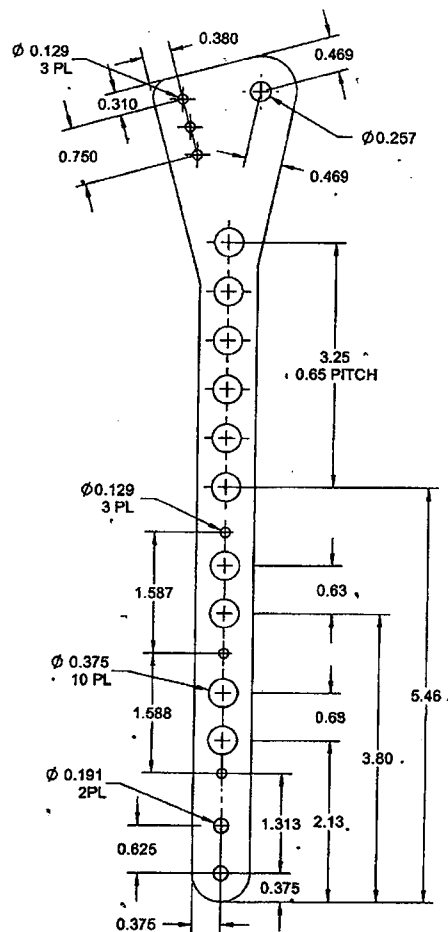
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.132	✓			
Ø .191	+ .005 - .001	.192	✓			
Ø .257	+ .006 - .001	.259	✓			
Ø .375	+ .006 - .001	.378	✓			
.310	± .010	.304	✓			
.380	± .010	.382	✓			
.750	± .010	.753	✓			
.469	± .010	.466	✓			
.469	± .010	.467	✓			
3.25	± .030	3.250	✓			
.65	± .030	.652	✓			
.63	± .030	.632	✓			
1.587	± .010	1.589	✓			
1.588	± .010	1.591	✓			
.63	± .030	.630	✓			
5.46	± .030	5.46	✓			
3.80	± .030	3.801	✓			
2.13	± .030	2.120	✓			
1.313	± .010	1.314	✓			
.375	± .010	.373	✓			
.625	± .010	.628	✓			
11.15	± .030	11.151	✓			
.750	± .010	.756	✓			
.125	± .010	.117	✓			

Measured by: <i>VB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-5-29	Date: 10/05/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



59247

RELEASED  
10-05-27 JH

**NOTES:**

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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

**D3908-1 AFT X-TUBE LUG PLATE**

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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